

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-027169**Date Inspected:** 09-Feb-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** Steve Jensen**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** SAS OBG**Summary of Items Observed:**

Caltrans Office of Structural Material (OSM) Quality Assurance Inspector (QAI) Joselito Lizardo was present at the Self Anchored Suspension (SAS) job site as requested to perform observations on the welding of components for the San Francisco Oakland Bay Bridge (SFOBB) Project.

At OBG 6W PP46.5 W2 deck access hole infill plate to top deck plate outside, QA randomly observed ABF/JV qualified welder Wai Kitlai continuing to perform CJP groove welding fill pass then cover pass on the east radius portion of the butt joint. The welder was observed perform automatic welding in the 1G (flat) position utilizing a Bug-o track mounted dual shield Flux Cored Arc Welding (FCAW-G) with E71T-1M, 1/16" diameter wire electrode and implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-3030-1. The joint being welded had a single V-groove butt joint that has been root welded without backing bar. The splice joint was preheated to greater than 150 degrees Fahrenheit using propane gas torch prior welding. During welding, ABF Quality Control (QC) Steve Jensen was noted monitoring the welding parameters of the welder. During the shift, fill pass welding on radius portion of the butt joint was still continuing when the observations on the FCAW welding was turned over to fellow QA Rob De Armond due to other job assignment.

FW Spencer:

At location Panel Point PP54 and PP56 of OBG grid line W2, FW Spender welder Damian Llanos was observed performing 6G (all position) Shielded Metal Arc Welding (SMAW) welding root pass to cover pass on the 1" & 2" weldolet branch of the 2.5" and 4" domestic water and compressed air lines. The welder was noted welding the root pass with 3/32" diameter E6010 electrode and followed by fill pass to cover pass using 3/32" diameter

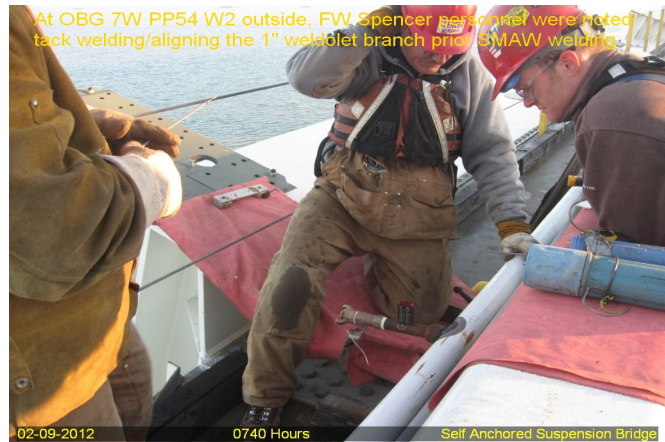
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E7018H4R electrode implementing Caltrans approved procedure FW Spencer WPS 1-12-1. The welder was noted preheating and removing the moisture of the joint using a portable propane gas torch prior welding. During welding, ABF QC Steve Jensen was noted monitoring the parameters of the welder. At the end of the shift, two (2) two weldolet field weld joints on each line (2 ½" & 4") were completed and visually accepted by QC. This QA performed VT verification on the completed weld splices and they appear in compliance to the Contract requirements. The following were welded and inspected during the shift;

Line Service Line/Pipe Size Panel Point Location Joint Designation

- 1 Domestic Water 1" weldolet 54 Northwest 1/DW1/54/NW
- 2 Compressed Air 2" weldolet 54 Northwest 1/CA2/54/NW
- 3 Domestic Water 1" weldolet 56 Northwest 1/DW1/56/NW
- 4 Compressed Air 2" weldolet 56 Northwest 1/CA2/56/NW



Summary of Conversations:

No significant conversation occurred today.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact SMR Nina Choy 510-385-5910, who represents the Office of Structural Materials for your project.

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Inspected By:	Lizardo, Joselito	Quality Assurance Inspector
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Reviewed By:	Levell, Bill	QA Reviewer
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